

Work Order ID 78322

January-05-12 9:03:20 AM

78322

Page 1

Item ID: D2432

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 206 (24") Bearpaw

Start Date: 1/05/12 Start Qty: 16.00

16

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

12-1-5

16

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

F.K. 12/01/19
RQ 12-1-20

12-1-5

140

0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

F.K. 12/01/19
RQ 12-1-20

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78322***78322***

Page 2

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Item ID: D2432

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206 (24") Bearpaw

Start Date: 1/05/12 Start Qty: 16.00

16

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location: _____

0.00

151

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/11/24
16

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Picklist Print

January-05-12 9:03:20 AM

Page 1

Work Order ID: 78322

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw

Start Date: 1/05/12

Required Date: 1/13/12

Start Qty: 16.00

Required Qty: 16.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			120	sf	683.6443	3.7	59.2		B.12-1-5	

Location

Loc Qty

Loc Code

MAT018

360

120035

360

MAT019

323.6443158

117321

74.6

117738

95.8

117819

83.3

118814

1.5

119145

68.4443158

119.145

16

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DART AEROSPACE LTD		Work Order: 78322
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.063 x 45°	✓		FK-04	Vern.
B	5.500	+/-0.030	5.499	✓		"	"
C	0.200	+/-0.030	.188	✓		FK-06	Depth gauge
D	0.25 x 45°	+/-0.030	.25 x 45°	✓		FK-04	Vern.
E	R0.250	+/-0.030	.25	✓		rad gauge	
F	0.250	+/-0.010	.247	✓		FK-04	Vern.
G	0.625	+/-0.030	.634	✓		"	"
H	0.375	+/-0.010	.378	✓		"	"
I	0.950	+0.030/0.010	.956	✓		"	"
J	19.000	+/-0.030	19.000	✓		FK-05	Tape.
K	3.14	+/-0.030	3.14	✓		FK-04	Vern.
L	3.28	+/-0.030	3.28	✓		"	"
M	Ø0.260	+0.005/-0.000	.260	✓		"	"
N	Ø0.93	+/-0.030	.929	✓		"	"
O	0.30	+0.030/-0.000	.318	✓		FK-06	Depth gauge
P	23.750	+/-0.030	23.750	✓		FK-05	Tape.
Q	7.375	+/-0.030	7.375	✓		CHK-02	Vern.
R	4.250	+/-0.010	4.280	✓		FK-04	Vern.
S	2.000	+/-0.030	2.000	✓		"	"
T	9.000	+/-0.010	9.000	✓		CHK-02	Vern.
U	9.000	+/-0.010	9.000	✓		"	"
V	0.375	+/-0.010	.379	✓		FK-04	Vern.

Measured by: FK	Audited by: [Signature]	Prototype Approval: N/A
Date: 12/01/19	Date: 12/01/23	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF [Signature]

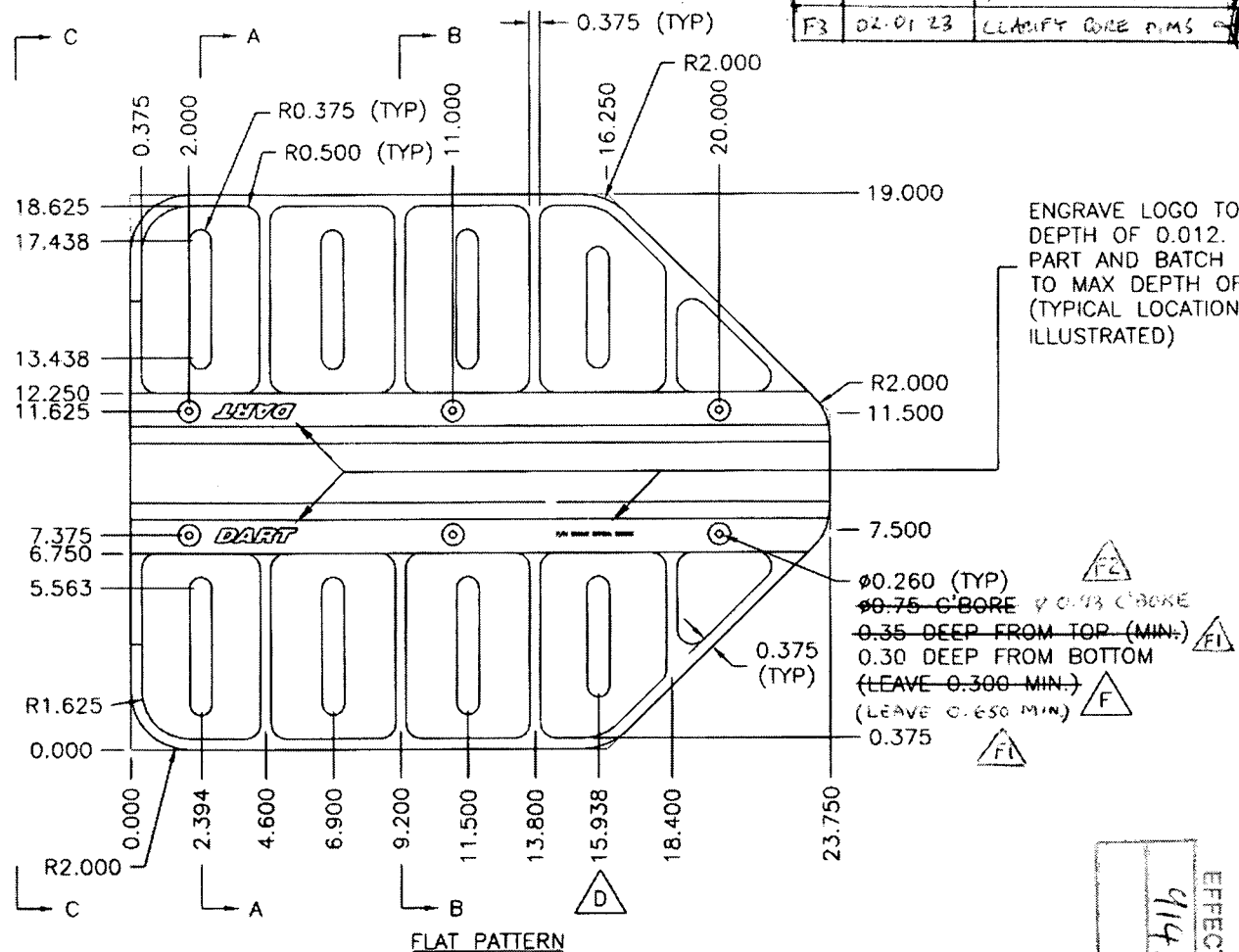
F1	99.03.12	ADD DEC 9143
F2	01.03.28	Ø0.75 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF

RELEASED
49 06 17 KG



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. F
KE	KE		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
MM	MM	D2432	
DATE	TITLE	SCALE	
98.05.12	BEARPAW	1:6	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	



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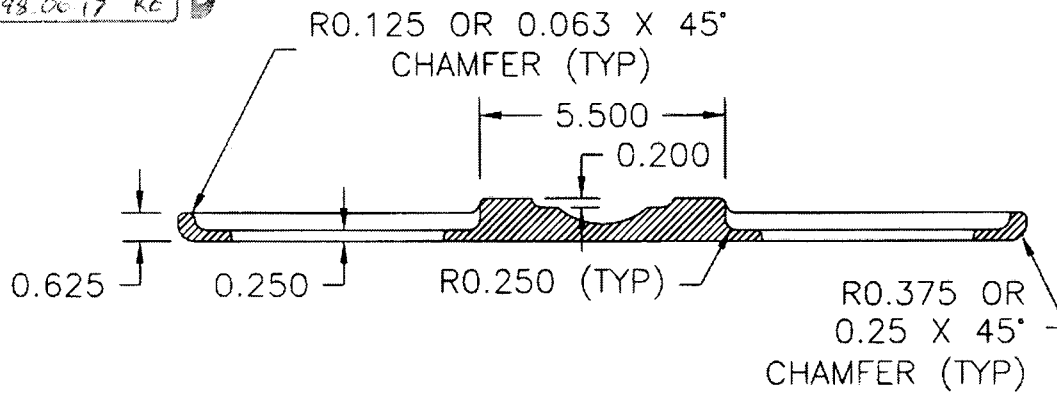
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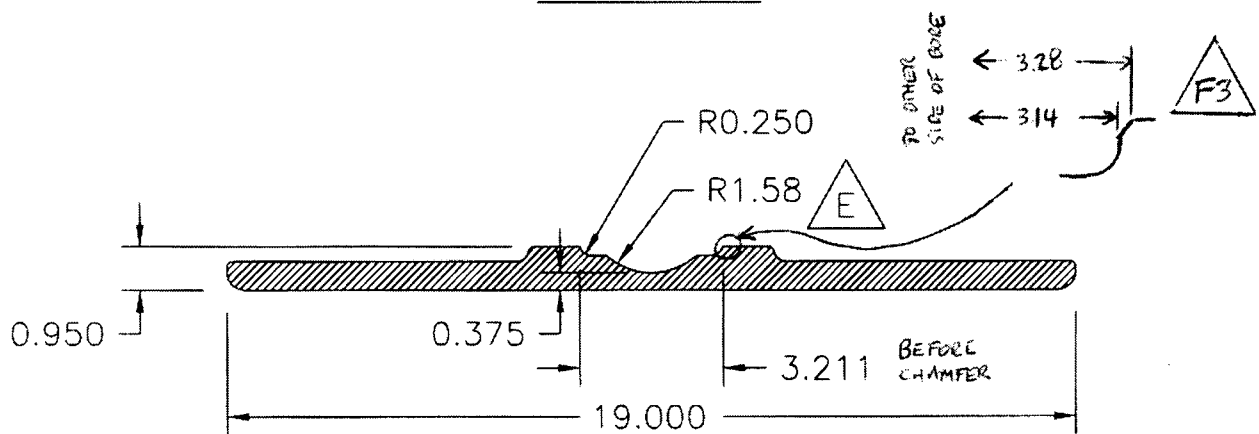


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

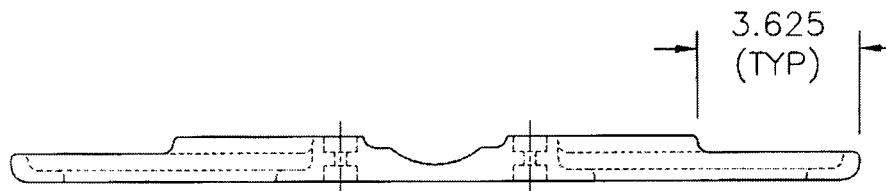
RELEASED
98-06-17 KE



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
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